

April-27-12 11:19:11 AM

83913

Item ID: D3825-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Rib Assembly (Basket End)

Stop *NS2*

Start Date: 27/04/2012 **Start Qty:** 2.00

~

Cust Item ID:

Required Date: 11/05/2012 **Req'd Qty:** 2.00

~

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/27

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	Rev A								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3825-1 rib as per dwg D3825								
	2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825								
	3- c'sink hole as per dwg								
	4- remove identification markings								
	5- deburr								
	6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825 A/R S.S. Rod Batch: <u>M 121602</u>								
	7- grind bushing weld flush where indicated on dwg D3825								
	8- deburr if necessary								

SAD 12-05-22

/CC 12-5-30

12-5-30

SAD

12-05-22

1cc 12-5-30
 12-5-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83913

83913

Page 2

April-27-12 11:19:11 AM

Item ID: D3825-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Rib Assembly (Basket End)

Stop *NS2*

Start Date: 27/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

6x PC 12.05.30

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

5.765/30

tlc

150

Identify as per dwg & Stock Location: WA

0.00

150

Packaging

Memo

0.00

Packaging

PC 12.05.30

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Work Order ID 83913***83913***

Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rib Assembly (Basket End)

Stop ***NS2***

Start Date: 27/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/30 9/10
ME
12-05-30

W/O:		WORK ORDER CHANGES					
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Picklist Print

April-27-12 11:19:17 AM

Page 1

Work Order ID: 83913

83913

Parent Item: D3825-041

D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	17.0000	1	2			

D2327-3

Spacer Bushing

**

SAD 12-05-22

Location	Loc Qty	Loc Code
WA	13	
82706	13	
WA005	4	
75564	1	
77229	1	
81144	2	

D3759-1

Manufactured No

100 Each

341.0000

1

2

D3759-1

Bushing

**

SAD R - 05-22

Location	Loc Qty	Loc Code
WA	135	
79213	135	
WA005	206	
66489	1	
82785	205	

6

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 83913

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)

83913

D3825-041

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

M304TS0.750W.065

Purchased

No

100

f

1,013.792

2.125

~~4473684~~

13.4271

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

SAP 12-08-22

Location

Loc Qty

Loc Code

MAT017

553.7325342

120267

53.7325342

120633

500

MAT018

453.40289

121170

412.40289

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

M118181

6.0667

M120633

13.4211

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

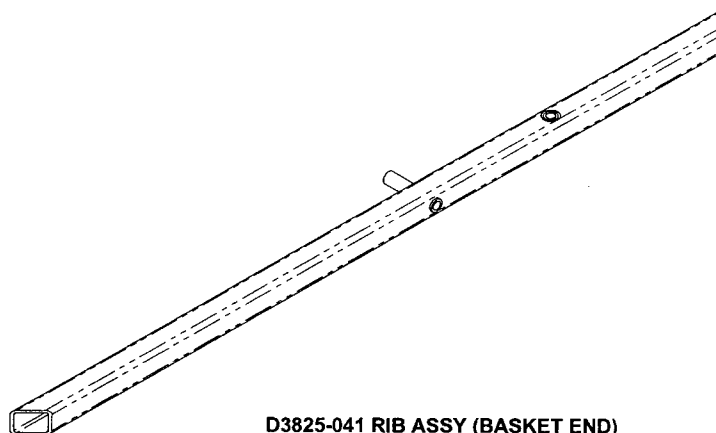
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83913 MCO
12/04/27

RELEASED
08/11/27

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) WELDING: PER DART QSI 004

REV.	NEW ISSUE	DESCRIPTION	MB	08.09.23
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.23			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET END)** SCALE NTS

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W/O:		WORK ORDER CHANGES					
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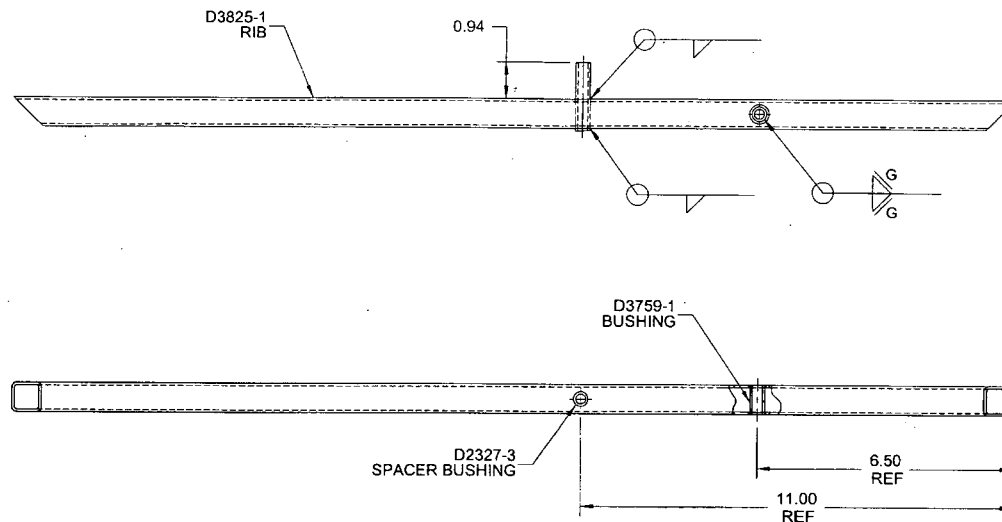
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

03913



D3825-041 RIB ASSY (BASKET END)

RELEASED
08/11/18 JWW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	08.09.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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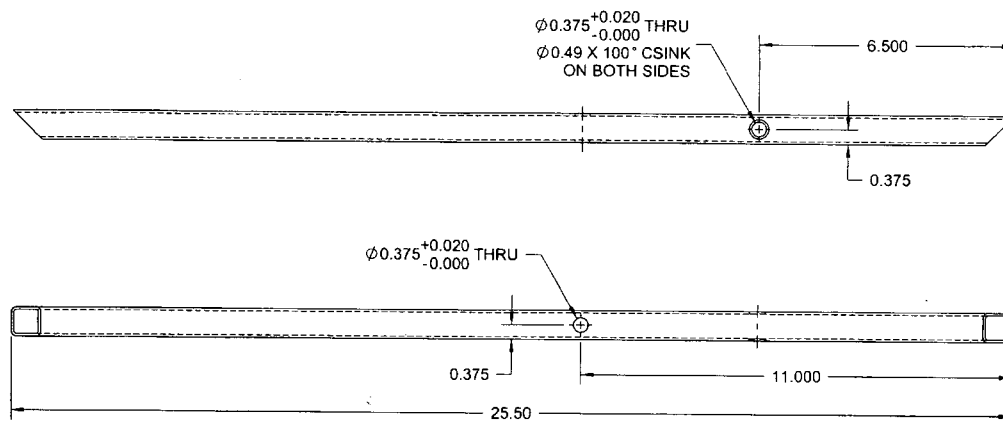
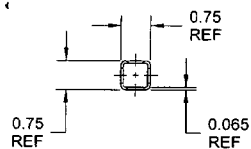
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83913



D3825-1 RIB

RELEASED
08/11/13 NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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